

Monday, 1/7/2008 3:42:06 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOOR ASSEMBLY		
Job Number	: 36652A			Part Number	: D41269401		
Estimate Number	: 11454			Drawing Number	: D412-694		
P.O. Number	:			Project Number	: N/A		
This Issue	1/7/2008	S.O. No.	:	Drawing Revision	: C1		
Prsht Rev.	: NC			Material	:		
First Issue	1/1	Type	SMALL /MED FAB	Due Date	2/28/2008	Qty:	1
Previous Run	: 27340A			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev: A 05.12.09, New Issue KJ/RF						
	: Est Rev: B 06.04.18 New dwg rev. ecn781 EC						
	: Est Rev: C 06.07.11 Revised per B24660 KJ						

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-01 CHG005

2.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Drill Process

1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).

Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041-042 bracket assembly as per Dwg D412-694 page 4 (view P).

4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2-T3 as per Dwg D412-694 page 2.

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section-C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

✓ 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

ml08/02/04

3.0 8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

m 15893 (xss)

m 107007

31 Jan 2009

ml08/02/04

4.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

PTD

ml08/02/07

5.0 QC5

INSPECT WORK TO CURRENT STEP



Jan 02-02 ①

Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

6.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045 Primer Filler

Batch: 106 803

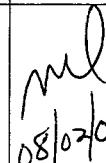
A/R 12375S Reducer

Batch: 106 803

2T 08 02-08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/07  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/07	4	Find Small crack at Bottom soft where inserts and Seal D3116-9	 08/02/07	fill up with Hyral EA 934 NA and milled fiber m 107007 EX 31 Jan 2009 let cure 24 Hours	 08/02/07	 08/02/07	 08/02/07	 08/02/07

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



*1602-080*



Comment: INSPECT WORK TO CURRENT STEP

8.0 D31105

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

*B27081*

*ml*

9.0 D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

*B36152*

*ml*

10.0 D31167

Seal ZX2054



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

*M27239*

*ml*

11.0 D31169

Seal ZX1267



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

*B17463*

*ml*

12.0 D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

*B24338X1*

Bracket Assembly

Batch

*B36727X2*

*ml*

13.0 D3121043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

*B21379*

*ml*

*ml 08/02/07*

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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Description :

14.0 D31221 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

B25539

*ml*

15.0 D31231 Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

M 10536-17

*ml*

16.0 D31241 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

M 10536-17

*ml*

17.0 D31242 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

M 10536-17

*ml*

18.0 D31261 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

B36728

*ml 08/02/13*

19.0 D31263 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

B24680

*ml*

20.0 D31265 Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

B18656 X1

*(X2)*

B36729 (X4) ml 08/02/13

W/O:		WORK ORDER CHANGES					
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation:

Description :

21.0 D3132041 Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

*ml*

22.0 D3133042 Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

*ml*

23.0 D3135041 Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

B36730 ✓

*ml*

24.0 D3137045 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

*ml*

25.0 D31381 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B25178 ✓

*ml*

26.0 D31391 Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B18863

*ml*

27.0 D31393 Guard



D3139 ml 2008/2/15

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B24751

*ml*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36652A		Part Number: D41269401
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
28.0	D314005 	Door Kit 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Door Kit Batch <u>B36652A</u>	<u>M106688</u> <u>ml 2008/2/15</u>
29.0	D31411 	Spring #204-032-734-001 
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spring #204-032-734-001 Batch <u>B34725</u>	<u>ml</u>
30.0	D31443 	Doubler 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Doubler Batch <u>B18816</u>	<u>ml</u>
31.0	D314413 	Doubler 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Doubler Batch <u>B21911</u>	<u>ml</u>
32.0	D3144109 	Doubler 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Doubler Batch <u>B23145</u>	<u>ml</u>
33.0	D3144111 	Doubler 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Doubler Batch <u>B21910</u>	<u>ml</u>
34.0	D31481 	Clevis 
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Clevis Batch <u>M10536-17</u>	<u>ml 08/02/08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Job Number: 36652A		Part Number: D41269401
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
35.0	D3151041 	Doubler Assembly 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Doubler Assembly Batch <u>B24685</u>	<i>ml</i>
36.0	D3152041 	Bracket Assembly 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B18867</u>	<i>ml</i>
37.0	D3155041 	Bracket Assembly 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B27178</u>	<i>ml</i>
38.0	D3155042 	Bracket Assembly 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B26933</u>	<i>ml</i>
39.0	D31561 	Bracket 
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bracket Batch <u>B24772</u>	<i>ml</i>
40.0	D3162041 	Bracket Assembly 
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s) Bracket Assembly Batch <u>B24688 (x8)</u> <u>B 36733 (x2)</u>	<i>ml</i>
41.0	D3162043 	BRACKET ASSEMBLY 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B24451</u>	<i>ml</i>
		<i>ml 08/02/07</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 36652A		Part Number: D41269401
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
42.0	D3162044 	BRACKET ASSEMBLY 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B36734</u>		<i>ml</i>
43.0	D3163041 	Cover Assembly 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cover Assembly		<u>B27349</u> <i>ml</i>
44.0	D3183041 	Bracket Assembly 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Batch <u>B37193</u>		<i>ml</i>
45.0	D32031 	Handle 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Handle Batch <u>B30158A</u>		<i>ml</i>
46.0	D33081 	Doubler 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Doubler Batch <u>B21912</u>		<i>ml</i>
47.0	AN52510R6 	Screw 
Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Screw Batch <u>M15943</u>		<i>ml</i>
48.0	AN52510R7 	Screw 
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Screw Batch <u>M106166</u>		<i>ml</i>
<i>ml 08/02/07</i>		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Description :

49.0 AN960JD8 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch M106112

*ml*

50.0 AN960JD10L Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch 104374

*ml*

51.0 AN960JD10LL Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch M19600

*ml*

52.0 AN960JD416L Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch M106303

*ml*

53.0 BSP45 Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch 11821

*ml*

54.0 BSP46 Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch M101237

*ml*

55.0 M7885243 → CR 3213-4-03 Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch 14477

*ml 08/01/17*

W/O:		WORK ORDER CHANGES					
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Description :

56.0 M7885344

Rivets



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Rivets

Batch

M7885344 19099

ml

57.0 MS20392C09

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11784

ml

58.0 MS20392C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18949

ml

59.0 MS20392C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M104156

ml

60.0 MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

M1563

ml

61.0 MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M3457

ml

62.0 CR3212404

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

N/A

See Step 56.0

ml 08/01/17

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Seq. #:	Machine Or Operation:	Description :
63.0	MS21042L4 	Nut 
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut Batch <u>M105054</u>	<i>ml</i>
64.0	MS21042L08 	Nut 
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Nut Batch <u>M105925</u>	<i>ml</i>
65.0	MS21072L3 	Nutplate 
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nutplate Batch <u>M18728 (x1)</u>	<u>M107003 (x3)</u> <del>ml</del> <i>ml</i>
66.0	MS24665151 	Cotter Pin 
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Cotter Pin Batch <u>M14526</u>	<i>ml</i>
67.0	MS24693S271 	Screw 
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Screw Batch <u>M14478</u>	<i>ml</i>
68.0	MS24694C5 	Screw 
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Screw Batch <u>11755 x 1</u>	<u>M106815 x 3</u> <i>ml</i>
69.0	MS24694S5 	Screw 
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Screw Batch <u>M18949</u>	<i>ml</i> 08/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

70.0 MS24694S50

Screw



✓

Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

M104625

ml

71.0 MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

103684

ml

72.0 MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M3501

ml

73.0 MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M11754X4

M106815X10

ml

74.0 MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

M105076

ml

75.0 MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

11822

ml

76.0 MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11822

ml08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

77.0 MS356503252 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11735

*ml*

78.0 MS518597 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M 106421

*ml*

79.0 NAS43DD310 Spacer



NAS43DD310FC

2008/2/15

Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M 19099

*ml*

80.0 NAS43DD314 Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

M 19347

*ml 08/01/17*

81.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

*ml 08/02/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

82.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

83.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover ( $\varnothing 0.250"$ )

4- Open  $15/64"$  (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: M 105700 Expiry Date: 23 July 2009

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

84.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function

*10/02/21*

*10/08/2011*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: DP Date: 01/02/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

85.0 COMPOSITE ASSY COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1- Finish installing D3163-041 in the door.
- 2- Install red decal before closing cover.

*mlo8/02/21*

*mlo8/02/21*

86.0 QC5 INSPECT WORK TO CURRENT STEP



*J08-02-220*



Comment: INSPECT WORK TO CURRENT STEP

87.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:       

*C408/02/26*

*(1)*

88.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*H08/02/26*

Job Completion



*m 2008/2/26 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

05-12-10

Qty	Qty	Qty	Qty	Part Number	Description
-01	-02	-03	-04		
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
	X			D412-694-03	DOOR ASSEMBLY
	X			D412-694-04	DOOR ASSEMBLY
1	1			D3110-1	ESCUTCHEON
	1	1		D3103	HANDLE
1	1			D3105	HANDLE ASSEMBLY
	1	1		D3114-041	PLATE ASSEMBLY
2	2			D3112-1	GUIDE
1	1			D3113-1	SPRING
	1	1		D3114-1	PIN
1	1			D3115-1	BRACKET
	1	1		D3116-11-0180	SEAL
	1	1		D3116-5-0890	SEAL
1	1			D3116-7-0890	SEAL
1	1			D3116-9-0770	SEAL
	1			D3119-041	COVER ASSEMBLY
	1			D3119-042	COVER ASSEMBLY
	1			D3120-1	COVER
	1			D3120-2	COVER
	1			D3120-3	COVER
	1			D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
1				D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
	1	1		D3125-1	LEVER
	1	1		D3125-3	LEVER
	1	1		D3125-5	LEVER
	1	1		D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3128-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
	1	1		D3128-1	SHIM
	2	2		D3129-1	LEVER
	2	2		D3130-1	CLEMS BASE
	1	1		D3131-1	STOP
	1			D3132-041	ROD WELDMENT
	1			D3132-042	ROD WELDMENT
1				D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
	1	1		D3134-1	ROD
	1	1		D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
	1			D3138-1	COVER
	1			D3138-2	COVER
	1			D3139-1	GUARD
	1			D3139-3	GUARD
	1			D3139-4	GUARD
	1			D3140-05	DOOR
	1			D3140-06	DOOR
2	2			D3140-07	DOOR
	1			D3140-08	DOOR
	2	2		D3141-1	SPRING
	1	1		D3143-1	CLEMS
3	3			D3143-3	CLEMS
1				D3144-1	DOUBLER
1				D3144-3	DOUBLER
1	1			D3144-105	DOUBLER
1	1			D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty	Qty	Qty	Qty	Part Number	Description
-01	-02	-03	-04		
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
		1		D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
	2	2		D3147-1	PIN
2	2			D3148-1	CLEMS
	2	2		D3149-1	STRIKER PLATE
	2	2		D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
		1		D3152-042	BRACKET ASSEMBLY
	1	1		D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3155-1	BRACKET
	3	3		D3159-041	BRACKET ASSEMBLY
	1			D3159-043	BRACKET ASSEMBLY
	1			D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1	1			D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
1				D3163-042	COVER ASSEMBLY
1				D3163-041	BRACKET ASSEMBLY (ROLLER)
1				D3163-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3208-1	HANDLE ASSEMBLY
2	2			D3208-1	DOUBLER
55	21	21	21	80-005-28	INSERT (FOR SL2052-3-4)
10	10			AN825-10R6	SCREW
8	8	4	4	AN825-10R7	SCREW
	8	8		AN860UD10	WASHER
18	18	4	4	AN860UD10L	WASHER
13	13	32	32	AN860UD10L	WASHER
6	6			AN860UD10L	WASHER
	4	4		AN860UD6L	WASHER
6	6			AN860UD8	WASHER
	2	2		AN860UD8L	WASHER
	2	2		AN860UD8LL	WASHER
	10	10		AS4-032-80	INSERT
87	87	50	50	BSF45	RIVET
	12	12		FWM10-032	WASHER
	6	6		FWM4-032	WASHER
12	12			M7885-24	RIVET (OR CR313-4-3)
	3	3		M7885-34	RIVET (OR CR312-4-3)
	2	2		MS2046AD4	RIVET
	7	7		MS2039-2015	PIN
2	2	2	2	MS2039-2C17	PIN
	2	2		MS2039-2C29	PIN
2	2			MS2039-3C21	PIN
8	8			MS2046AD3	RIVET
12	12			M7885-3-4	RIVET
8	8			MS2042-6AD4	RIVET

Qty	Qty	Qty	Qty	Part Number	Description
-01	-02	-03	-04		
20	20			MS2046AD4	RIVET
	6	6		MS21042-05	NUT
6	6	2	2	MS21042-08	NUT
	5	5		MS21042-13	NUT
4	4			MS21042-14	NUT
4	4			MS21072-13	NUTPLATE
6	6	9	9	MS2465-151	COTTER PIN
4	4			MS2469-5271	SCREW
4	4			MS2469-53	SCREW
6	6			MS2469-55	SCREW
18	18			MS2469-550	SCREW
	4	4		MS2469-556	SCREW
	2	2		MS2469-563	SCREW
	4	4		MS2469-590	SCREW
4	4			MS2469-591	SCREW
2	2	2	2	MS2528-16	CLAMP
2	2	2	2	MS7039-1-05	SCREW
14	14	12	12	MS7039-1-05	SCREW
13	13	6	6	MS7039-1-08	SCREW
	2	2		MS5205-231	SCREW
2	2			MS5205-233	SCREW
	4	4		MS5650-305	NUT
2	2			MS5650-325	NUT
2	2	3	3	M56169-7	WASHER
	4	4		NA51169-10L	WASHER
14	14			NA5388-8P	SCREW
15	15			NA5391BSP	WASHER
7	7			NA5400C3-10	SPACER
6	6			NA5400C3-14	SPACER
	2	2		NA5400C3-40	SPACER

## GENERAL NOTES:

- 1 FOR ADJUSTMENT OF LOOKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUT OUT SHOULDER IN VIEW.
- 2 IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEMS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- 3 HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. E30-2000-01; D3144-T1-T2-T3; DT8703-9; D3162-041T1 (FOR-01 DOOR ASSY); E30-2000-02; D3144-T4-T7-T8-T9; DT8703-9; D3162-041T2 (FOR-02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-T4-T2 (FOR-03 DOOR ASSY); D3144-T10-T11-T12; D3119-02T1; D3112-T4-T2 (FOR-04 DOOR ASSY)
- 4 INSTALL INSERTS PER DART QSI 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.

5 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6 ALL DIMENSIONS ARE IN INCHES

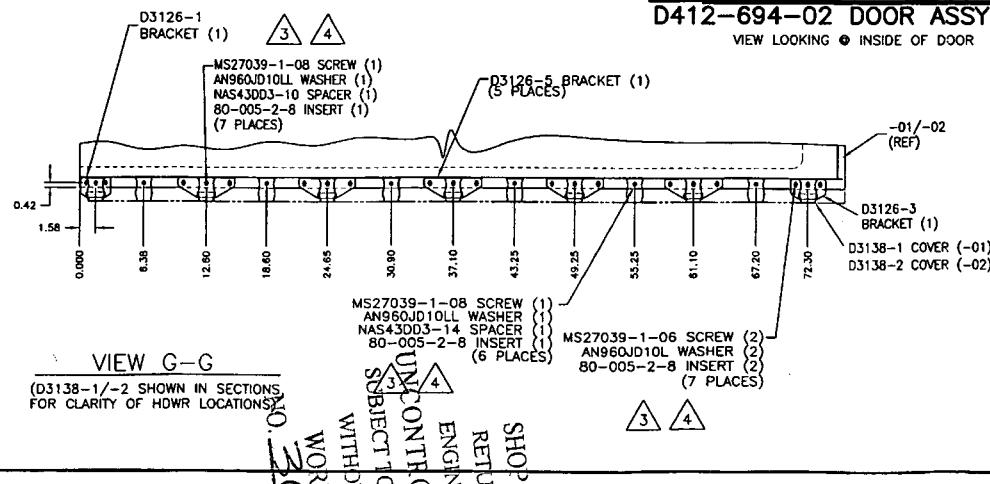
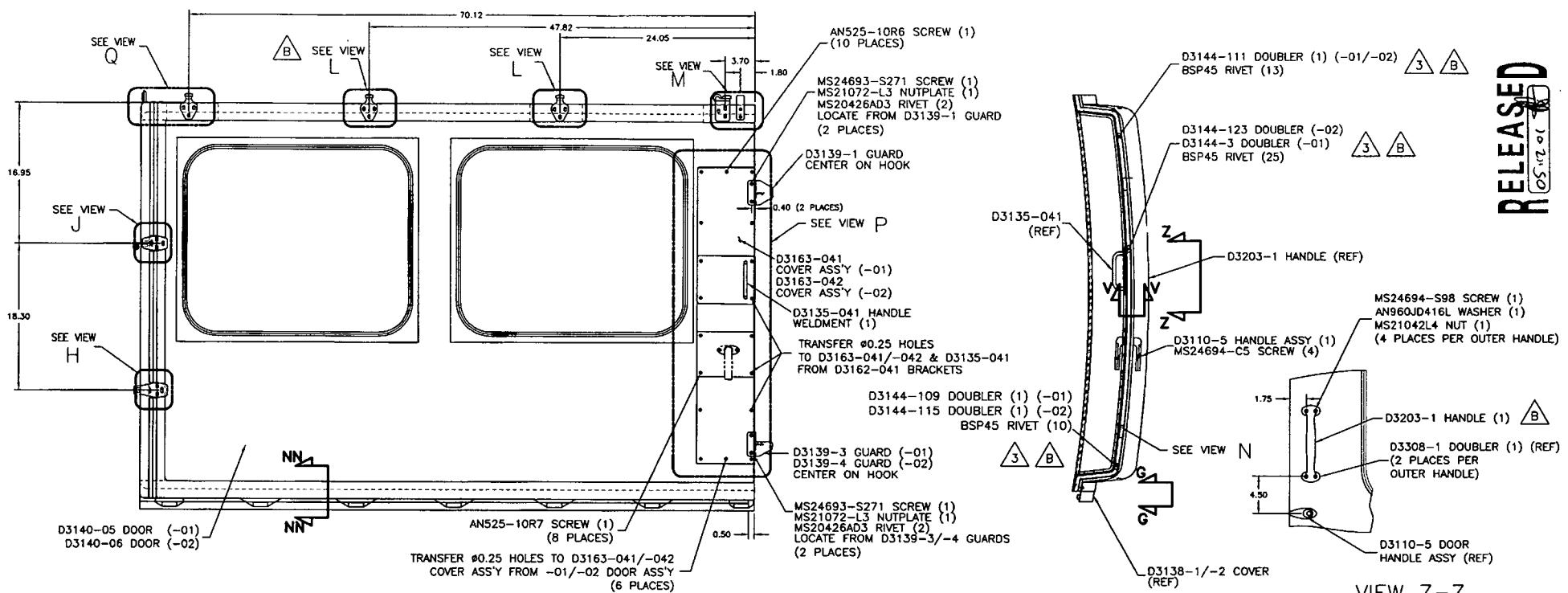
7 IDENTIFY D412-694-01/02-03-04 DOOR ASSEMBLIES USING D272-1 DECALS

CI	06.03.28	ADD OPTION M7835/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN CP	DRAWN BY RF	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D412-694
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS
		REV. C SHEET 1 OF 6

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DESIGN

CP

RF

CHECKED

APPROVED

DART

DART AEROSPACE LTD.

HANDBURY, ONTARIO, CANADA

DRAWING NO.

D412-694

REV. C

SHEET 2 OF 6

SCALE

N/A

DATE

05.11.23

TITLE

DOOR ASSEMBLY

WORK ORDER NO. 36652A

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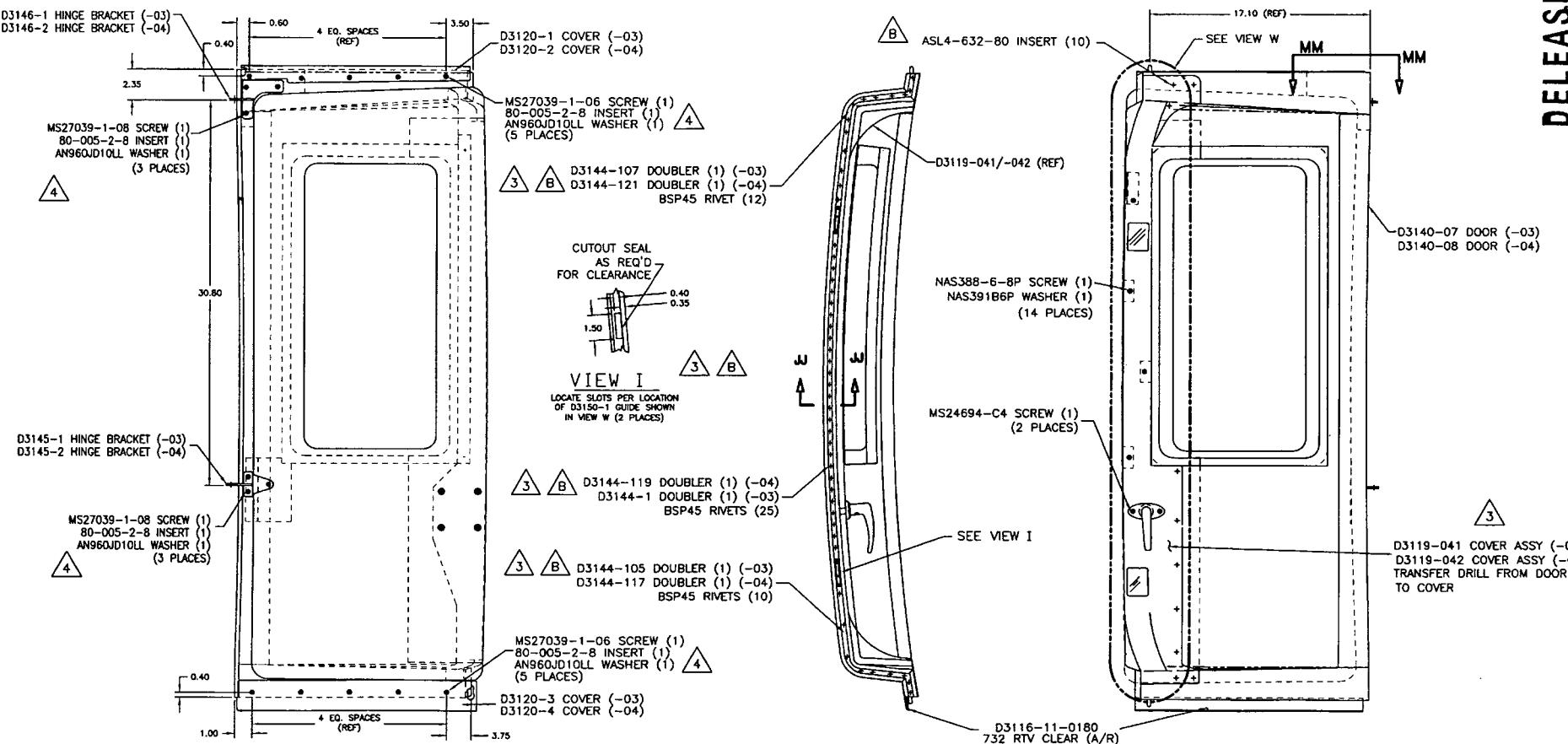
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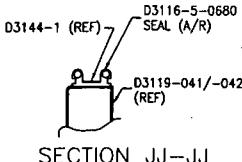
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**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**



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NO. 36622A

WORK ORDER

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DESIGN

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RF

CHECKED

APPROVED

DART

DART AEROSPACE LTD.

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D412-694

REV. C

SHEET 3 OF 6

DATE

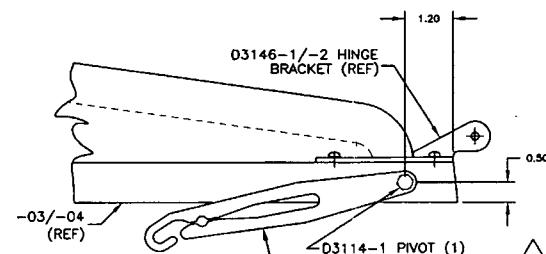
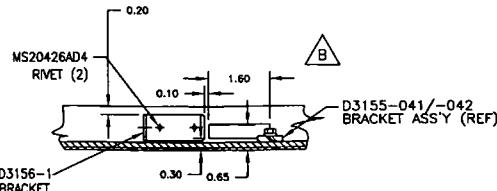
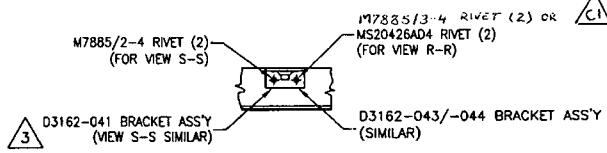
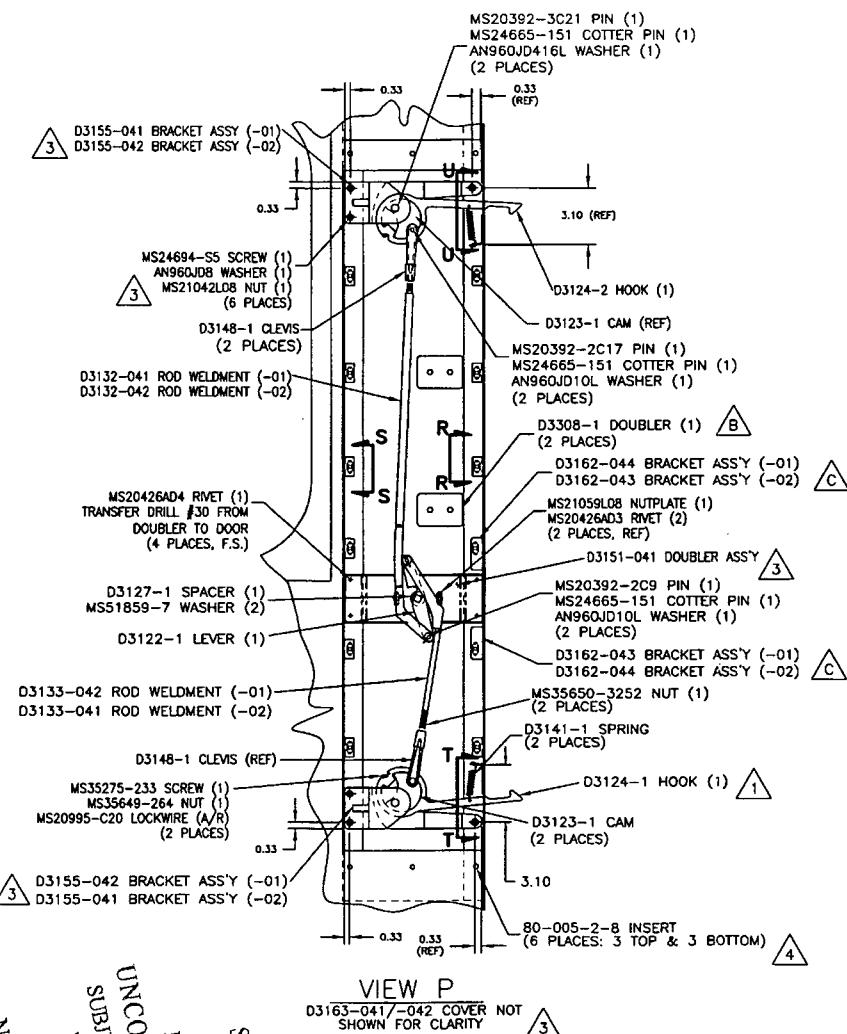
05.11.23

TITLE

DOOR ASSEMBLY

NTS

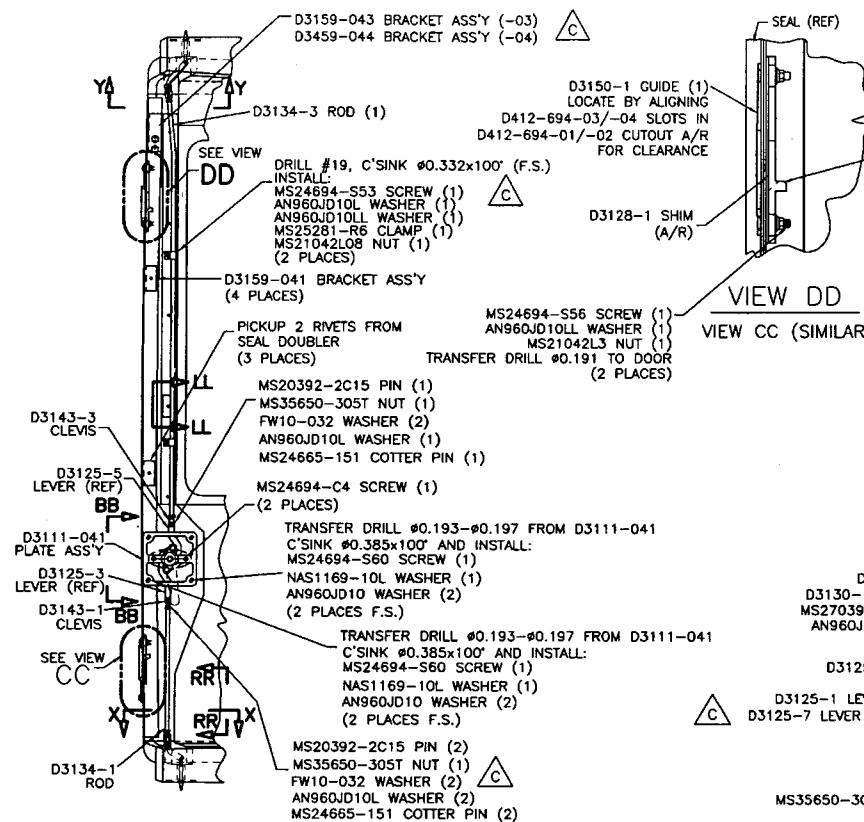
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S-57-01



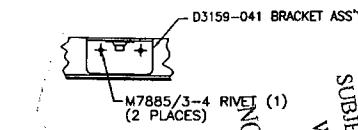
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DATE 05.11.23				TITLE DOOR ASSEMBLY	SCALE NTS



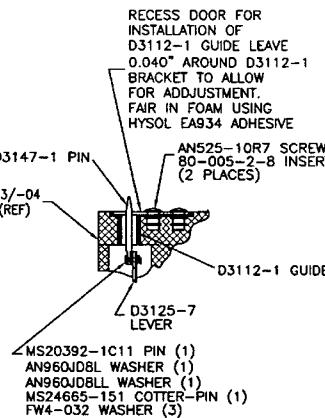
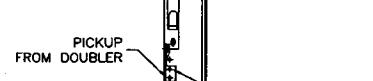
VIEW W  
D3119-041/-042 COVER ASSY NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY



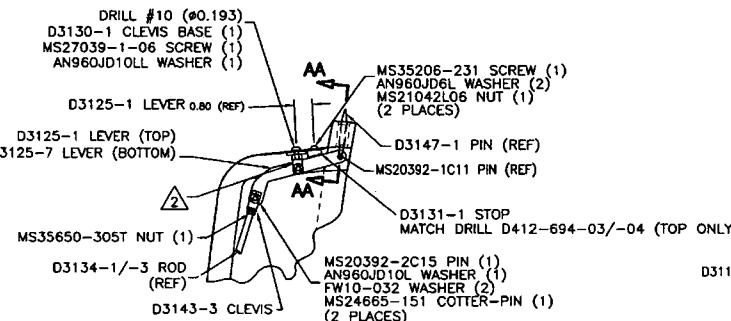
SECTION LL-LL  
(3 PLACES)  
VIEW ROTATED 90°CCW

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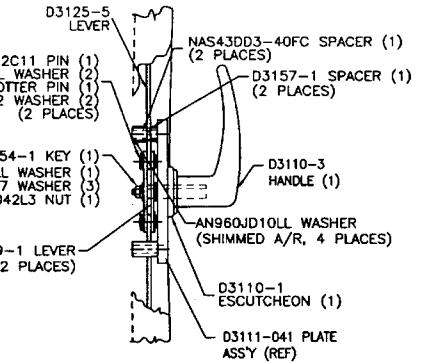
VIEW RR-RR



SECTION AA-AA

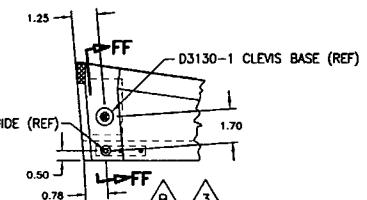


SECTION FF-FF



SECTION BB-BB

VIEW SHOWN WITH MECHANISM IN THE UNLOCKED POSITION FOR CLARITY



SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

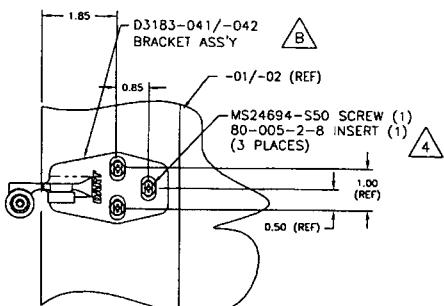
D3125-1 LEVER NOT SHOWN FOR CLARITY

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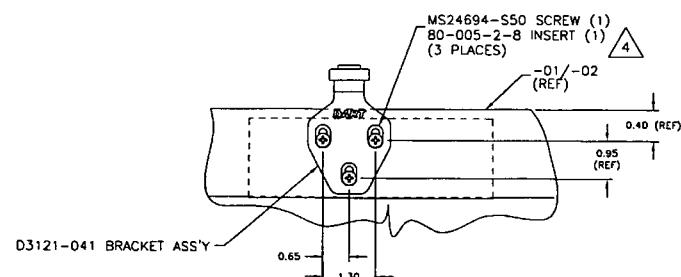
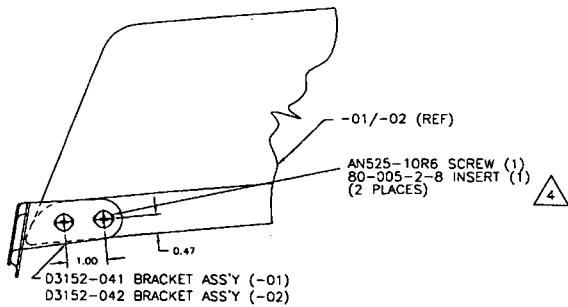
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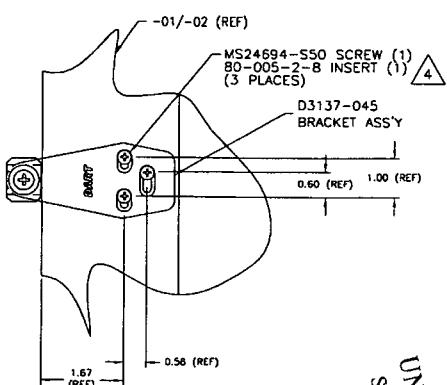


VIEW J

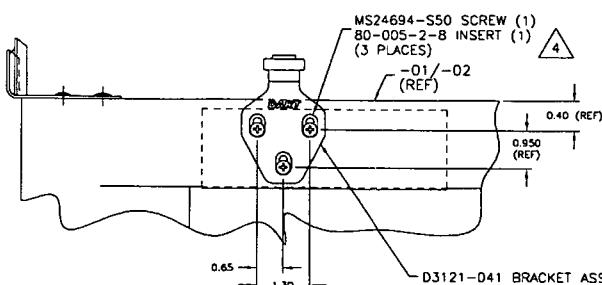


VIEW L

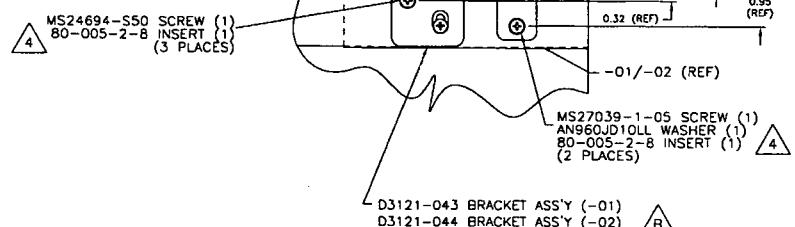
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05-12-01



VIEW H



VIEW Q



VIEW M

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